



Dart Aerospace Ltd.
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K6A 1K7
Canada

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RB877212-08-2
Job Sheet 192386



Part No: RB877212-08-2

Job Qty: 1 pcs

Part Name: Bearing Cutter Tool Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/22/19

Job Tracking No:

Due Date: 5/3/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *orden 13636*

Note: DWG RB877212-08 Rev D IPP Rev. A 19.02.21 New issue DP Verify DD/IPP Rev. B 19.03.20 drawing revision DP Verify DD

Ship Via:

Bill of Materials



Container No: S190962



Part: RB877212-08-2

Job No: 192386

Serial No/Batch: S190962

Revision: D

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/17/19

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	5/3/19	0.00	0.20		Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	5/3/19	0.00	0.00		QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
120	Packaging 3-1 - Stock - B4B	1 pcs	5/3/19	0.00	0.00		Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
130	QC 21 - SA	1 pcs	5/3/19	0.00	0.00		QC 21 - SA - 21		
							QC 21 - SA - 70		
							QC 21 - SA - 53		

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TBO

Part Op 100 - Assemble as per DWG.

Descriptions: 120 - The tool must be packaged with a desiccant bag into a tight fitting sealed plastic bag as per DWG.

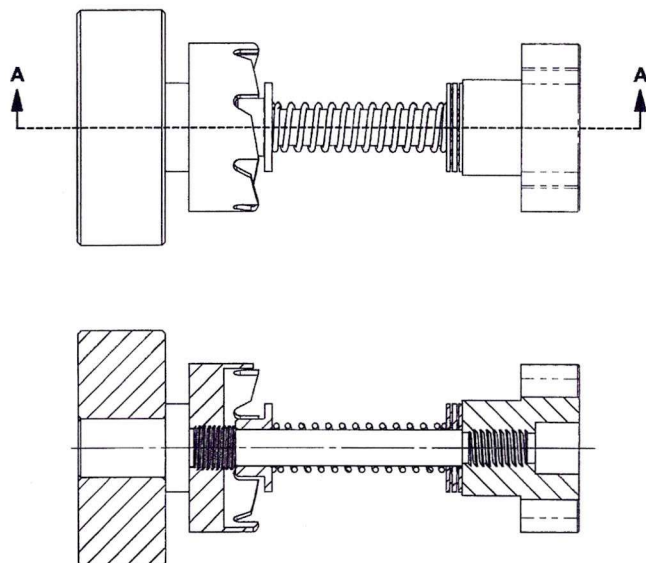
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
38 9657K389 ✓	Compression Spring	1 (1 ea)	100-Small Fab - 1 3175978	38 572647
23 DK-55 ✓	Knob	1 Ea (1 ea)	100-Small Fab - 1 3088953	23 5051749
34 NTA-512 ✓	Bearing	1 Ea (1 ea)	100-Small Fab - 1	34 5057540
141E RB877212-08-1 ✓	Shaft, Ø3/4 x 4	1 pcs (1 ea)	100-Small Fab - 1	141E 5175990
96 RB877212-08-3 ✓	Handle, Ø2 x 3/4	1 pcs (1 ea)	100-Small Fab - 1	96 5169967
RB877212-08-7 ✓	Cutter, Ø1-1/2 x 5/8	1 pcs (1 ea)	100-Small Fab - 1	95 5175987
141E RB877212-08-9 ✓	Spring Guide, Ø3/4 x 5/16	1 pcs (1 ea)	100-Small Fab - 1	141E 5176149
36 TRA-512 ✓	Washer	2 Ea (2 ea)	100-Small Fab - 1	36 5060994
				5070537

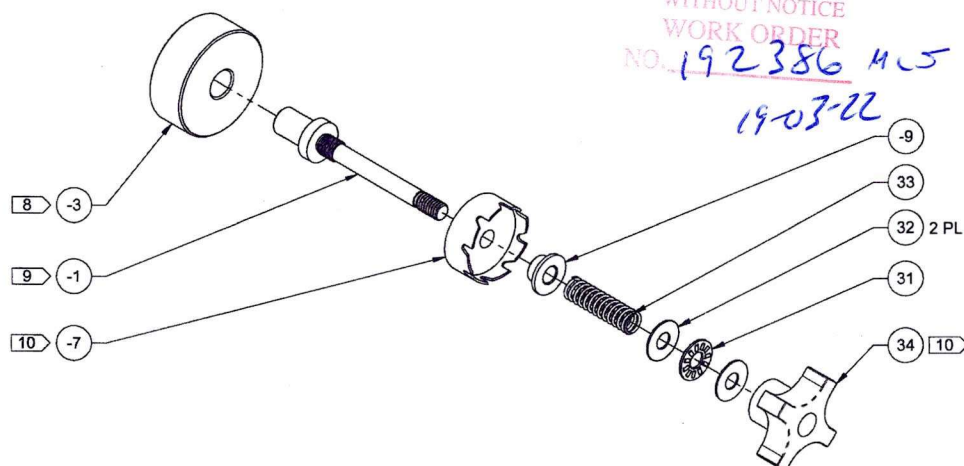
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	9657K389	1	0	0
	DK-55	1	10	0
	NTA-512	1	18	0
	RB877212-08-1	1	0	0
	RB877212-08-3	1	0	0
	RB877212-08-7	1	0	0
	RB877212-08-9	1	0	0
	TRA-512	2	35	0
Part Specifications				
Specifications could not be found.				

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ITEM #	QTY	PART #	PART TITLE
-1	1	RB877212-08-1	SHAFT
-3	1	RB877212-08-3	HANDLE
-7	1	RB877212-08-7	CUTTER
-9	1	RB877212-08-9	SPRING GUIDE
31	1	NTA-512	NEEDLE ROLLER THRUST BEARING 5/16" ID. X 3/4" OD. X 5/64" WD.
32	2	TRA-512	THRUST WASHER 5/16" ID. X 3/4" OD. X 0.03" WD.
33	1	McMaster#9657K389 OR EQUIV.	ZINC PLATED MUSIC WIRE COMPRESSION SPRING 2" LG. x 0.42" OD. x 0.326" ID. CLOSE AND GROUND ENDS
34	1	Reid#DK-55 OR EQUIV.	KNOB 4-PRONG 5/16-18 UNC



SECTION A-A



RB877212-08-2 BEARING CUTTER TOOL ASSY

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NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM -3 WITH ITEM -1, AND REMOVE EXCESS
- 9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS 3/8"-24 UNF ONLY OF ITEM -1 THEN ASSEMBLE WITH ITEM -7, AND REMOVE EXCESS
- 10) INSTALL ITEMS -7 & 34 HAND TIGHT
- 11) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	MBB	DART AEROSPACE LTD	
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. D
MFG. APPR.	DP	RB877212-08	SHEET 2 OF 11
APPROVED	VH	TITLE	SCALE
		TAIL ROTOR BEARING CUTTER	NTS
DATE	3/21/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 192386 MJS
19-03-22

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					